

Splil

Work Order ID 70592-1

Wednesday, July 06, 2011 8:37:36 AM



Page 1

Item ID: D412-630-033

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli Access Step LH Folding

Start Date: 6/10/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 7/11/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

0.00

100



DC

DOCUMENT CONTROL

0.00

Memo

Document Control

Photocopy bluefile & create labels per PPP D412-630-033 CHG003

0.00

110



Small Fab

Small Fab

0.00

Memo

Small Fab

Assemble as per dwg D412-630 p.14
Coat all hardware with LPS3 rust inhibitor
A/R LPS3 batch: M109929
COAT exposed HARDWARE WITH LPS PROCYON
A/R LPS PROCYON BATCH: M114596

M 11 07 21 ①

After BG 11-7-21

EP 11/07/21-①

Work Order ID 70592

Wednesday, July 06, 2011 8:37:36 AM

Page 2

Item ID: D412-630-033

Accept

Revision ID:

Item Name: Heli Access Step LH Folding

Start Date: 6/10/2011 Start Qty: 3.00

Required Date: 7/11/2011 Req'd Qty: 3.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

130

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

140

QC4- 100% Inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control

150

ID+STOCK

MUG

160

QC 21- FINAL INSPECTION- W/O Release

11/7/21

11/7/21

11-06-21

Picklist Print

Wednesday, July 06, 2011 8:37:32 AM

Page 1

Work Order ID: 70592

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LJI Folding



Start Date: 6/10/2011

Start Qty: 3.00

Required Date: 7/11/2011

Required Qty: 3.00

Comments:

IPP Rev:A New Issue 06-11-08 JLM
 IPP rev B ecn 1019, added d2807-041 EC verified by:DD
 IPP rev:C 11.01.06 added route seq ID DD vef:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2012-107 Clevis		Manufactured	No			110	Each	15.0000	1	3		6/11/07/21	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		15							
				66811		15							
D2803-041 Bracket Assembly		Manufactured	No			110	Each	4.0000	1	3		6/11/07/21	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST149		4							
				61724		2							
				71006		2							
D2804-041 Bracket Assembly		Manufactured	No			110	Each	1.0000	1	3		6/11/07/21	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST150		1							
				61726		1							

Picklist Print

Wednesday, July 06, 2011 8:37:33 AM

Page 2

Work Order ID: 70592

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

D2807-041

Manufactured No

110 Each

25.0000

2 6



Door prop

Location

Loc Qty

Loc Code

ST022

17

60540

2

69671

15

ST023

8

68494

8



EP 11/07/11

D2813

Manufactured No

110 Each

21.0000

2 6



Washer

Location

Loc Qty

Loc Code

ST023

21

69386

21

110 Each

1.0000

1 3

D3562-041

Manufactured No



Step Assembly, LH

Location

Loc Qty

Loc Code

FG110

1

54963

1

110 Each

60.0000

4 12

D3395-1

Manufactured No



Rushing

Location

Loc Qty

Loc Code

ST052

60

69387

20

70775

40



EP 11/07/11

8
24

EP 11/07/11
370592
71382 (3)

Wednesday, July 06, 2011 8:37:33 AM

Shop Packet Print

Page 2

Picklist Print

Wednesday, July 06, 2011 8:37:33 AM

Page 3

Work Order ID: 70592

Parent Item: D412-630-033

Parent Item Name: Heli Access Step L11 Folding

Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

AN3C21A

Purchased

No

110

Each

77.0000

2

6



BOLT



EP 11/07/21

Location

Loc Qty

Loc Code

ST352

77

109148

7

117366

20

117514

50

1
5

AN8C16

Purchased

No

110

Each

37.0000

2

6



Bolt



EP 11/07/21

Location

Loc Qty

Loc Code

ST345

37

106066

37

6

AN310C8

Purchased

No

110

Each

33.0000

2

6



Nut



EP 11/07/21

Location

Loc Qty

Loc Code

ST324

33

117771

23

118091

10

6

MS24665-302

Purchased

No

110

Each

184.0000

6

18



Cotter Pin



EP 11/07/21

Location

Loc Qty

Loc Code

ST357

184

117460

184

18

Wednesday, July 06, 2011 8:37:33 AM

Shop Packet Print

Page 3

Picklist Print

Wednesday, July 06, 2011 8:37:33 AM

Page 4

Work Order ID: 70592

Parent Item: D412-630-033

Parent Item Name: Heli Access Step L11 Folding

Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

NAS1515H3

Purchased

No

110

Each

166.0000

4

12



Washer

Location

Loc Qty

Loc Code

ST277

166

116373

6

117460

60

118078

100



EP 11/07/21

NAS1515H5L

Purchased

No

110

Each

68.0000

4

12



WASHER

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

28

111359

28



EP 11/07/21

NAS1515H8

Purchased

No

110

Each

227.0000

4

12



Washer

Location

Loc Qty

Loc Code

ST278

227

111275

35

111411

192



EP 11/07/21

Wednesday, July 06, 2011 8:37:33 AM

Shop Packet Print

Page 4

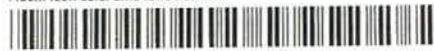
Picklist Print

Wednesday, July 06, 2011 8:37:33 AM

Work Order ID: 70592

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding



Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

MS21043-3

Purchased

No

110

Each

1.133.000

4

12



Nut



GP 11/07/01

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

1061

112314

69

118077

992

3 9

MS24693-C280

Purchased

No

110

Each

41.0000

2

6



Screw



GP 11/07/01

Location

Loc Qty

Loc Code

ST310

40

115594

10

118093

30

ST318

1

111279

1

4 2

D2806-1

Manufactured

No

130

Each

26.0000

2

6



Bushing



11/7/01 sl 12

Location

Loc Qty

Loc Code

ST022

26

68492

6

70885

20

2

Picklist Print

Wednesday, July 06, 2011 8:37:33 AM

Work Order ID: 70592

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding



Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

D2806-3

Manufactured No

130 Each

27.0000

2



Bushing



Handwritten '2' and '3' with a checkmark.

Location

Loc Qty

Loc Code

ST022

27

69401

7

70886

20

Handwritten '2' and '3' with a checkmark.

D2810-5

Manufactured No

130 Each

8.0000

1



Strut



Handwritten '3' and '5' with a checkmark.

Location

Loc Qty

Loc Code

ST265

8

52034

1

69402

7

Handwritten '1' and '3' with a checkmark.

D3396-1

Manufactured No

130 Each

38.0000

2



Spacer



Handwritten '6' and '11/7/2011' with a checkmark.

Location

Loc Qty

Loc Code

ST052

38

46748

8

69906

30

Handwritten '2' and '3' with a checkmark.

Picklist Print

Wednesday, July 06, 2011 8:37:33 AM

Work Order ID: 70592

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding



Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

AN4C6A

Purchased

No

130

Each

410.0000

1

3



Bolt



Location

Loc Qty

Loc Code

FG

4

103344

4

ST306

12

117313

12

ST356

394

116704

19

117619

150

117794

50

117872

75

118191

100

AN4C10A

Purchased

No

130

Each

73.0000

1

3



Bolt



Location

Loc Qty

Loc Code

ST356

73

112243

43

114523

30

AN5C15A

Purchased

No

130

Each

65.0000

2

6



Bolt



Location

Loc Qty

Loc Code

ST338

20

118191

20

ST339

45

111819

7

117764

13

117885

25

Picklist Print

Wednesday, July 06, 2011 8:37:34 AM

Page 8

Work Order ID: 70592

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding



Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

AN44C7A

Purchased

No

130

Each

65.0000



1

3

Eyebolt

Location

Loc Qty

Loc Code

ST362

65

109013

25

111308

40

130

Each

93.0000



2

6

AN4C15A

Purchased

No

Bolt

Location

Loc Qty

Loc Code

ST358

93

115835

11

117441

32

117795

50

130

Each

180.0000



7

21

NAS1515H4

Purchased

No

Washer

Location

Loc Qty

Loc Code

ST277

180

111525

2

116169

3

117460

50

117735

75

118078

50

Wednesday, July 06, 2011 8:37:34 AM

Shop Packet Print

Page 8

Picklist Print

Wednesday, July 06, 2011 8:37:34 AM

Work Order ID: 70592

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding



Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

NAS1515H5

Purchased

No

130

Each

167.0000

7

21



Washer

Location

Loc Qty

Loc Code

FG

40

103286

20

103691

20

ST277

127

103286

100

109430

27

130

Each

897.0000

4

12

MS21043-4

Purchased

No



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

857

117601

357

~~117793~~

500

130

Each

583.0000

3

9

MS21043-5

Purchased

No



Nut

Location

Loc Qty

Loc Code

FG

20

101418

20

ST301

463

112314

363

~~116546~~

100

ST314

100

118159

100

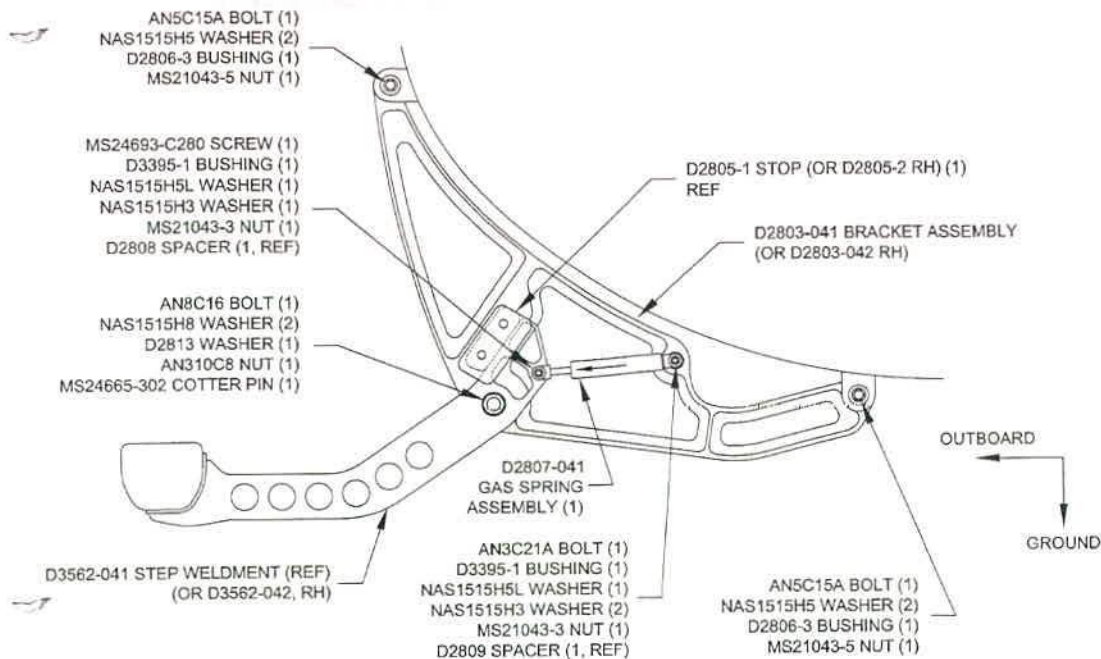
D412-630-033/-034 Heli-Access-Step™ Installation

FIGURE 25-13: STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)

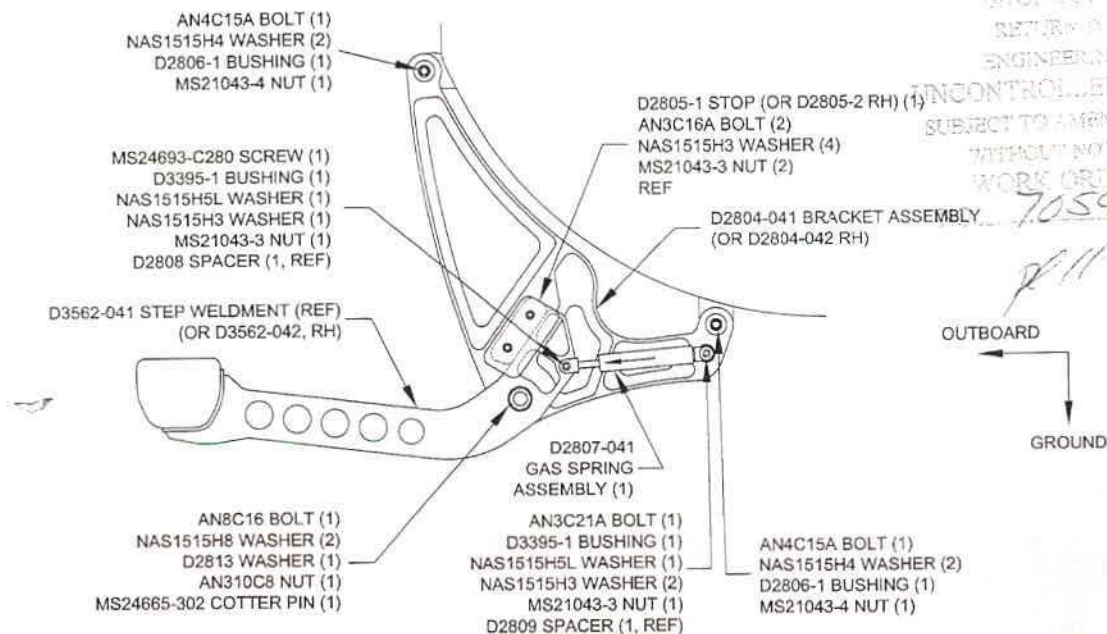


FIGURE 25-14: STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)

• COPYRIGHT © 2005 BY DART AEROSPACE LTD •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

25-00-00